Work Order ID 60306

Thursday, July 01, 2010 1:11:18 PM

Item ID: D4133-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Gasket

Start Date: 7/1/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/8/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-7-01 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4133	A								
100	FLOW WATER JET	0.00				ml	10	07	14 (2)
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4133 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				ml	10	07	14 (2)
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(12)			
QC	**Memo**	0.00							
Quality Control									

Scratch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 60306

Thursday, July 01, 2010 1:11:18 PM

Item ID: D4133-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Gasket

Start Date: 7/1/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/8/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:	0.00				10/7/14			
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							10-7-14
QC	**Memo**	0.00							
Quality Control									

MF
10-7-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 01, 2010 1:11:22 PM

Work Order ID: 60306

Parent Item: D4133-3

Parent Item Name: Gasket

Start Date: 7/1/2010 **Required Date:** 7/8/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	364.8531	2.735	5.757895			
NEOPRENE SHEET 0.063													

Location	Loc Qty	Loc Code	
MAT	259.6		
114691	259.6		
MAT052	105.2531		
114176	105.2531		

MM 10.07.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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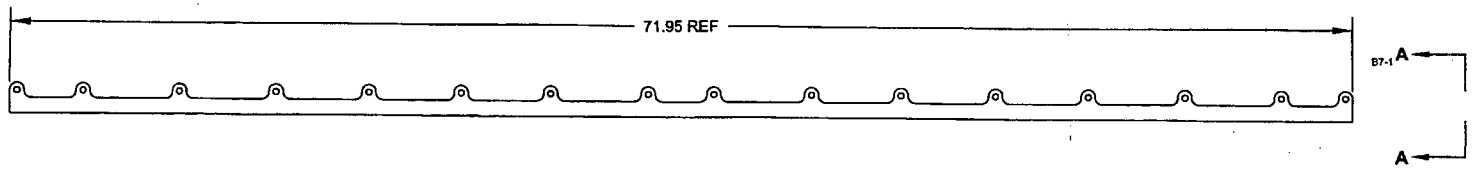
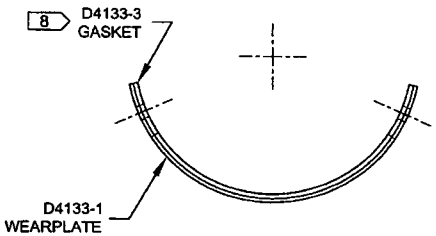
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D4133-041	WEARPLATE, MID
1	D4133-1	WEARPLATE
1	D4133-3	GASKET
A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



D4133-041 WEARPLATE, MID



C1-1 **VIEW A-A**
SCALE 4X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60304
6/10-7-01

RELEASED
2010-06-29

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4133-041" USING YELLOW PAINT MARKER ON INSIDE SURFACE
7) WEIGHT: 4.9 lbs
8) BOND D4133-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	10.06.15

DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	CP	PORT HADLOCK, WA
CHECKED	[illegible]	DRAWING NO. D4133 — REV. A
MFG. APPR.	[illegible]	SHEET 1 OF 4
APPROVED	[illegible]	TITLE: WEARPLATE, MID — SCALE: NTS
DE APPR.	[illegible]	
DATE	10.06.15	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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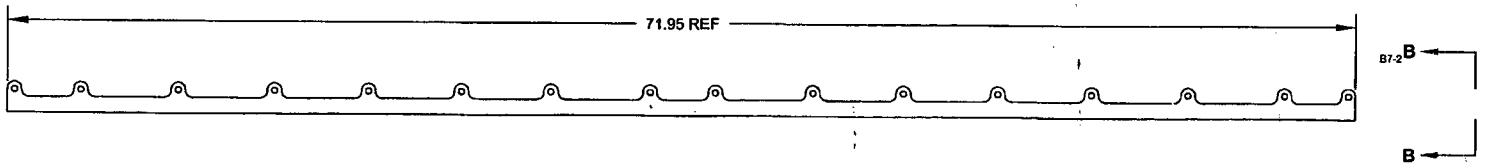
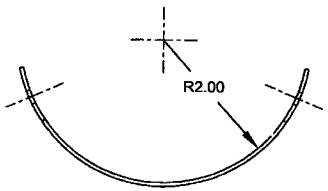
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D4133-1 WEARPLATE



C1-2 **VIEW B-B**
SCALE 4X

wo 60304

RELEASED
2010 -06- 29
MB

NOTES:
1) MATERIAL: MAKE FROM D4133-1F
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 4.0 lbs

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4133 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE, MID NTS
DATE	10.06.15	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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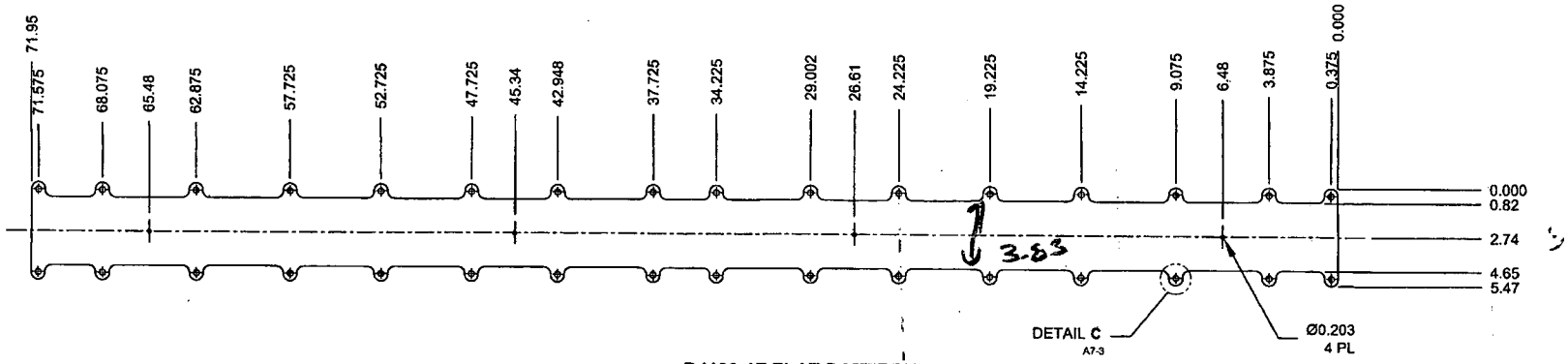
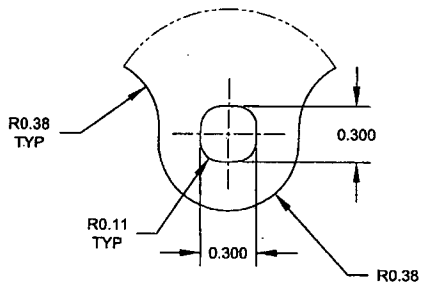
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D4133-1F FLAT PATTERN



DETAIL C C3-3
SCALE 10X

w/o 40306

RELEASED
2010 -06- 29

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524 OR ASTM A240, 18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 4.0 lbs

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4133 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE, MID NTS
DATE	10.06.15	

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Dart Aerospace Ltd

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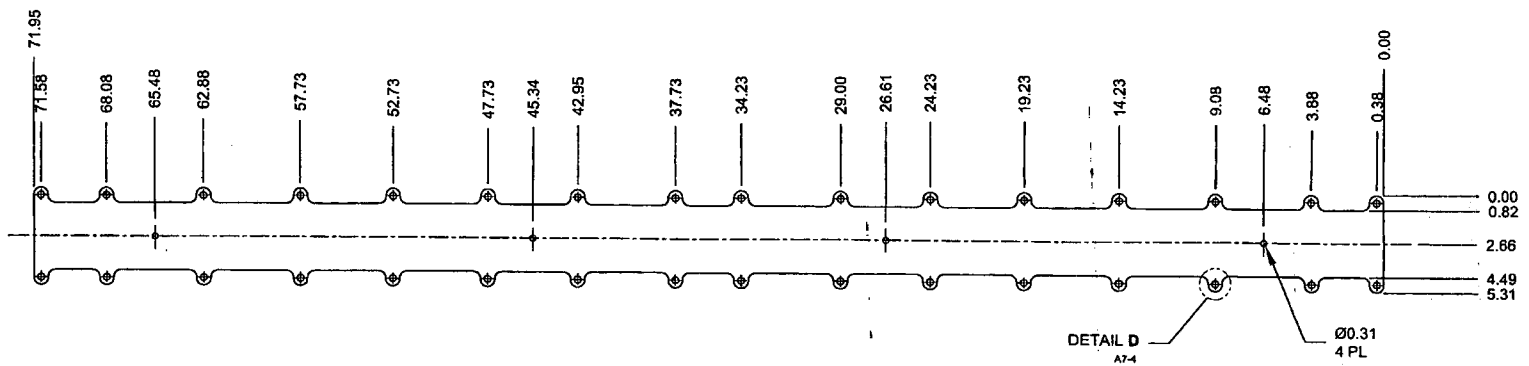
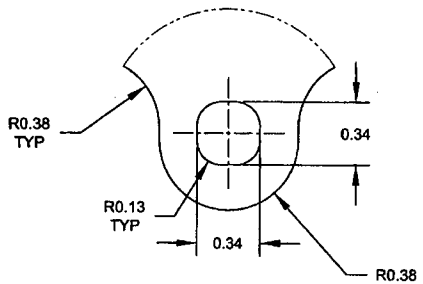


D4133-3 GASKET



DETAIL D C3-4
SCALE 10X

wo 60304

RELEASED
2010-06-29

NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 0.90 lbs

DESIGN		DART AEROSPACE USA, INC
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4133 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE, MID NTS
DATE	10.06.15	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60306
Description: Gasket	Part Number:	D4133-63
Inspection Dwg: D4133 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.31	+0.012-0.001	0.315	√		VWN	
0.34	+/-0.030	0.35	√		VWN	
0.34	+/-0.030	0.35	√		VWN	
5.31	+/-0.030	5.30	√		VWN	
71.95	+/-0.030	71.98	√		M.T	
6.48	+/-0.030	6.48	√		M.T	
26.61	+/-0.030	26.61	√		M.T	
45.34	+/-0.030	45.34	√		M.T	
65.48	+/-0.030	65.48	√		M.T	
34.23	+/-0.030	34.23	√		M.T	
37.73	+/-0.030	37.73	√		M.T	
68.08	+/-0.030	68.08	√		M.T	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10.07.14	Date:	10/07/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	